

Work Order ID 67754

Wednesday, March 30, 2011 10:13:45 AM



Page 1

Item ID:	D3651-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Aft Base Assembly					
Start Date:	3/30/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	4/1/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11/03-30	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3651	Rev B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per dwg D3651 2- Seal all mating surfaces and gaps using Proseal 700 fire wall sealant as per dwg D3651 Batch: M116667 3-install D3651-1 using 3M high performance contact adhesive 1357 as per dwg D3651 Batch: M105623								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

8/11/05/18

8/11/05/17

8/11/05/19

2

2

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 67754



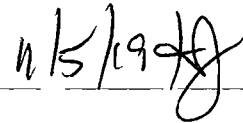
Page 2

Wednesday, March 30, 2011 10:13:45 AM

Item ID: D3651-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Aft Base Assembly
Start Date: 3/30/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 4/1/2011 Req'd Qty: 2.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00		800 1105/19		②			
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/5/19 

11-05-19
②

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 30, 2011 10:14:14 AM

Page 1
2

Work Order ID: 67754

Parent Item: D3651-041

Parent Item Name: Aft Base Assembly





Start Date: 3/30/2011

Required Date: 4/1/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																		
CR3523-4-02  RIVET		Purchased	No			100	Each	375.0000	58	116																					
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST312</td><td>200</td><td></td></tr><tr><td>116915</td><td>200</td><td></td></tr><tr><td>ST313</td><td>175</td><td></td></tr><tr><td>116391</td><td>100</td><td></td></tr><tr><td>116893</td><td>75</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST312	200		116915	200		ST313	175		116391	100		116893	75	
Location	Loc Qty	Loc Code																													
ST312	200																														
116915	200																														
ST313	175																														
116391	100																														
116893	75																														
D3651-043  Flange Weldment		Manufactured	No			110	Each	3.0000	1	2																					
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>GA</td><td>3</td><td></td></tr><tr><td>65543</td><td>3</td><td></td></tr></table>														Location	Loc Qty	Loc Code	GA	3		65543	3										
Location	Loc Qty	Loc Code																													
GA	3																														
65543	3																														
D3651-1  Gasket		Manufactured	No			110	Each	4.0000	1	2																					
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>GA</td><td>4</td><td></td></tr><tr><td>61748</td><td>4</td><td></td></tr></table>														Location	Loc Qty	Loc Code	GA	4		61748	4										
Location	Loc Qty	Loc Code																													
GA	4																														
61748	4																														
D3651-11  Gasket		Manufactured	No			110	Each	0.0000	1	2																					

1367755

2

B 67755 (2)

SB 11/05/18

44

72

SB 11/05/18

2

SB 11/05/18

2

SB 11/05/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 30, 2011 10:14:14 AM

Page 2

Work Order ID: 67754

Parent Item: D3651-041



Parent Item Name: Aft Base Assembly

Start Date: 3/30/2011

Required Date: 4/1/2011

Start Qty: 2.00

Required Qty: 2.00

D3651-13 Manufactured No 110 Each 4.0000 1 2
  SB 11/05/18
Outside Doubler

Location

Loc Qty

Loc Code



GA

4

67551

4

2

D3651-9 Manufactured No 110 Each 2.0000 1 2
  SB 11/05/18
Inside Doubler

Location

Loc Qty

Loc Code

GA

2

62814

2

2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

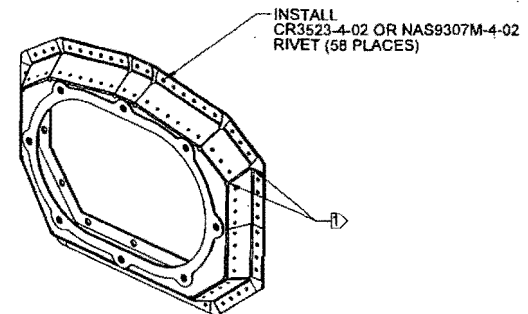
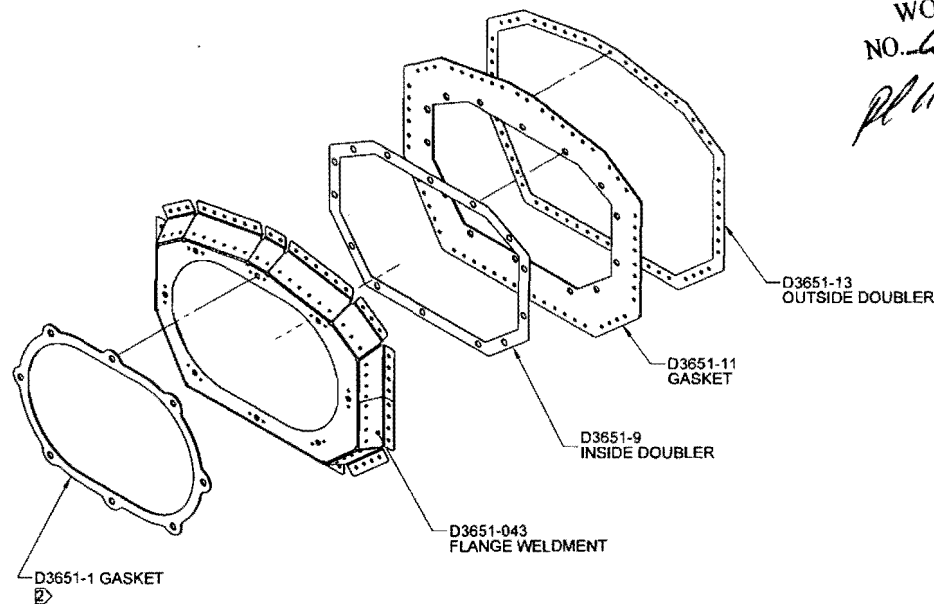
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 62754
PL 11-03-30



PART LIST

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

D3651-041 AFT BASE ASSEMBLY

D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.88; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3651 REV. B SHEET 1 OF 9 TITLE AFT BASE ASSEMBLY SCALE 1:4 COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COME OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	08.01.07		

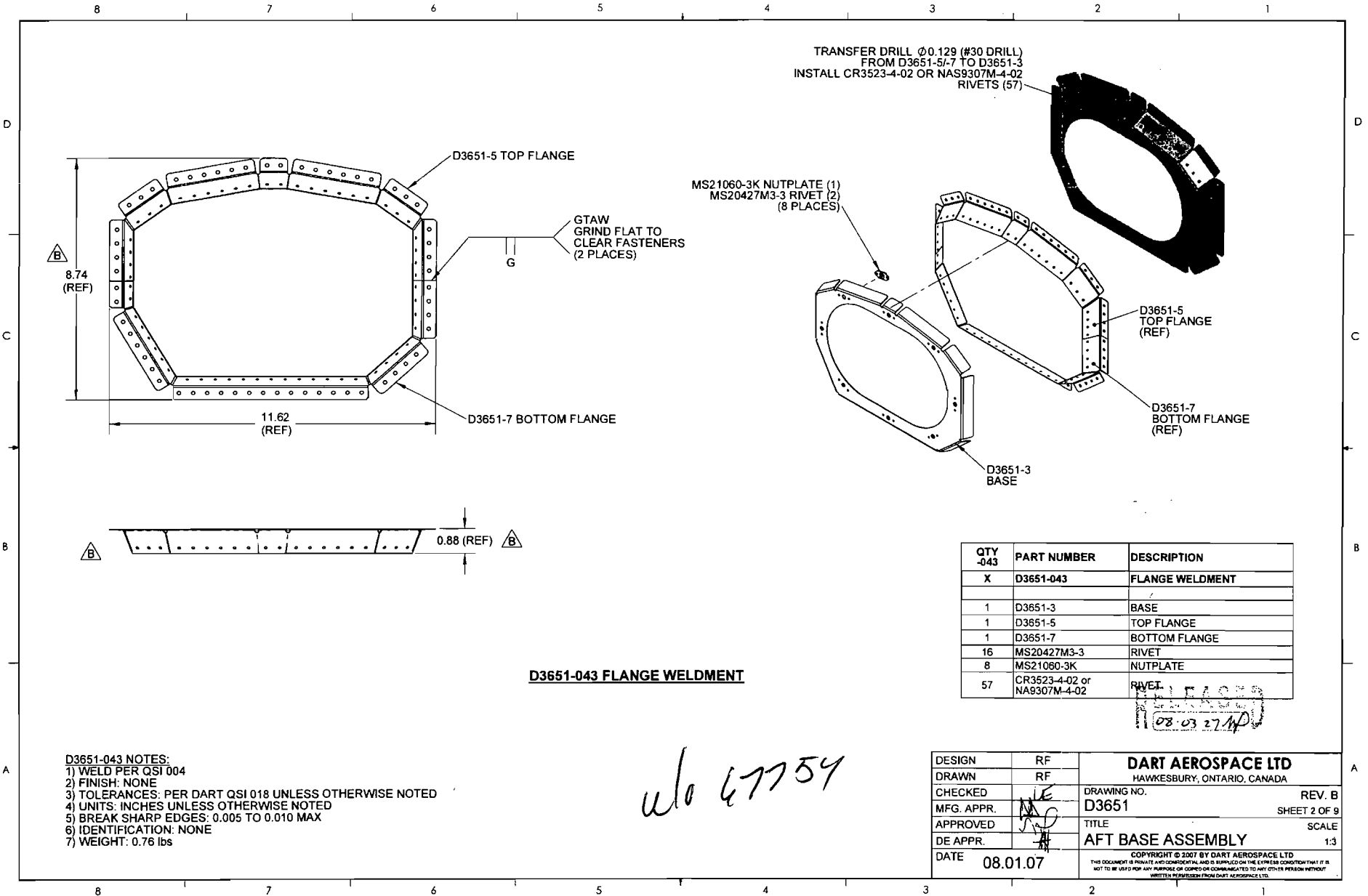
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NOTE: Date & initial all entries



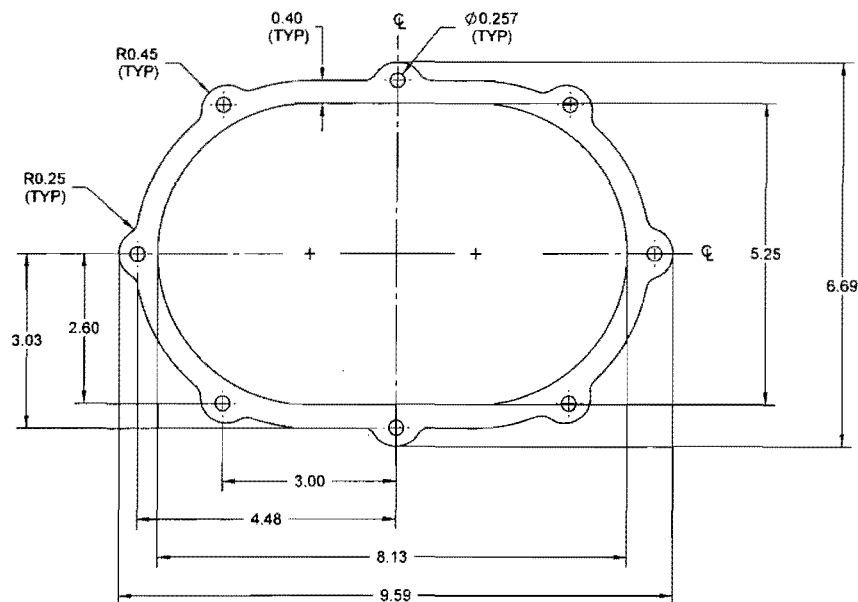
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NOTE: Date & initial all entries



D3651-1 GASKET

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT ϕ
- 8) WEIGHT: 0.09 lbs

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08-03-27

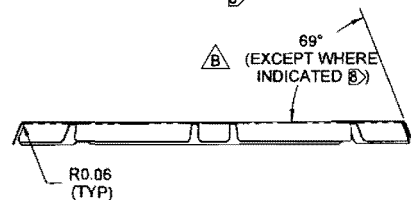
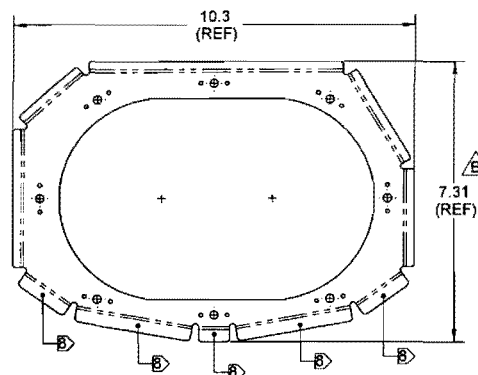
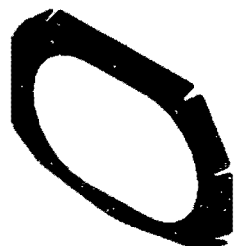
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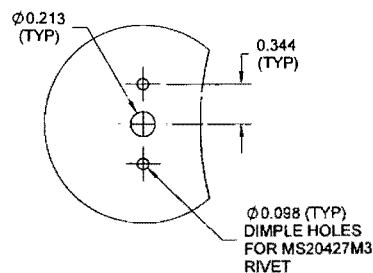
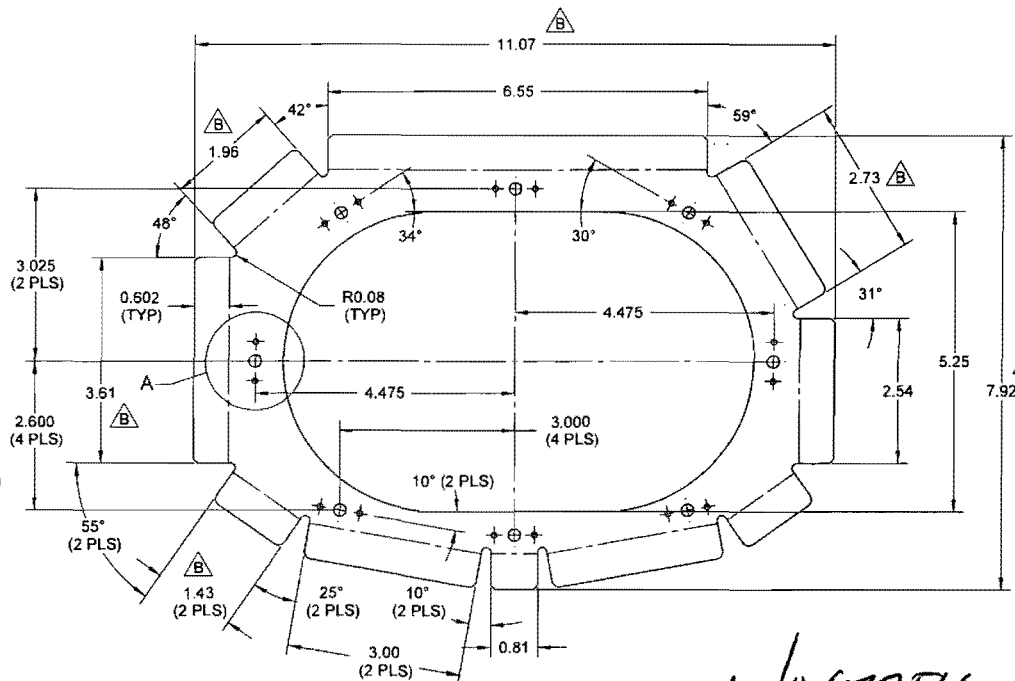
NOTE: Date & initial all entries



D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) BEND TO 55° WHERE INDICATED



DETAIL A

D3651-3F FLAT PATTERN

W/0 57754

08-03 27 MS

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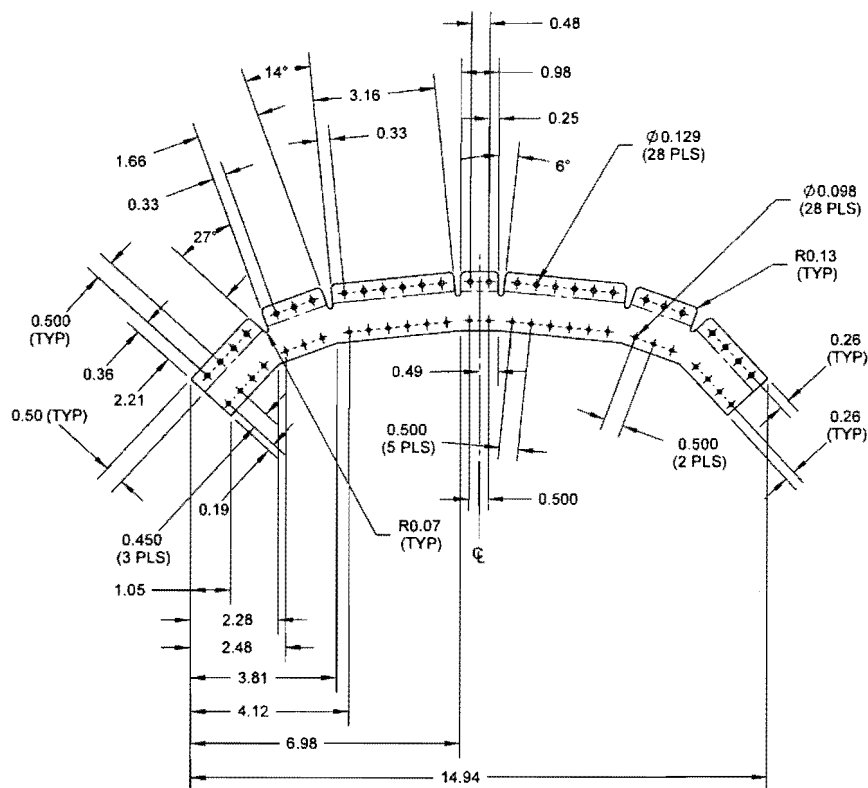
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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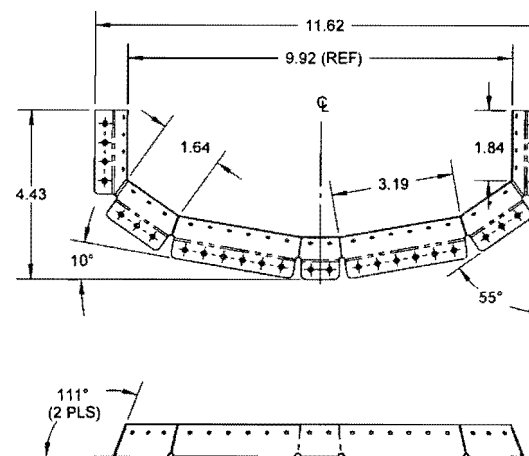
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3651-SF FLAT PATTERN



D3651-5 TOP FLANGE BEND DETAIL
(MAKE FROM D3651-SF FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

u/o 977 59

08-03-27 MP

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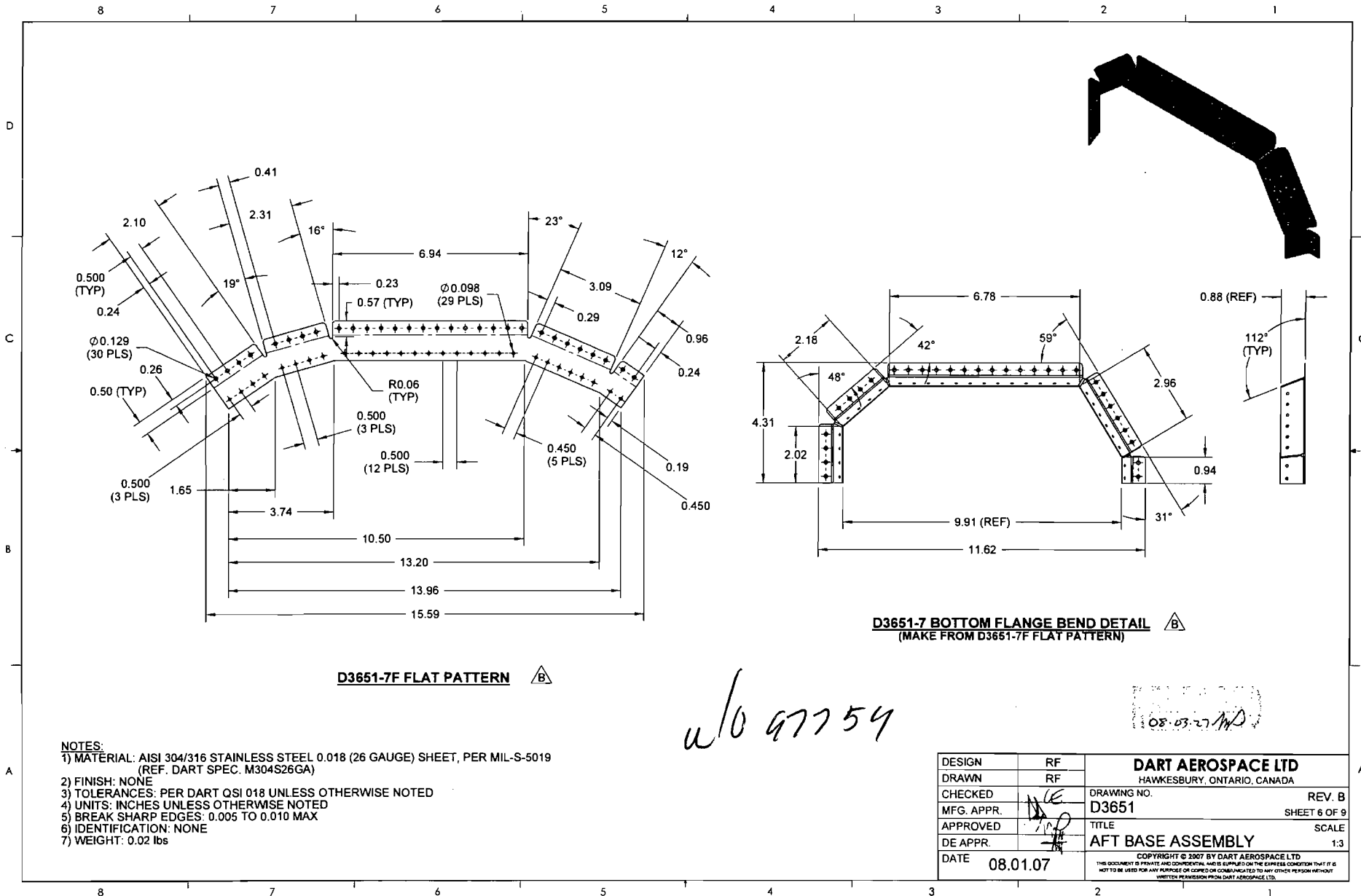
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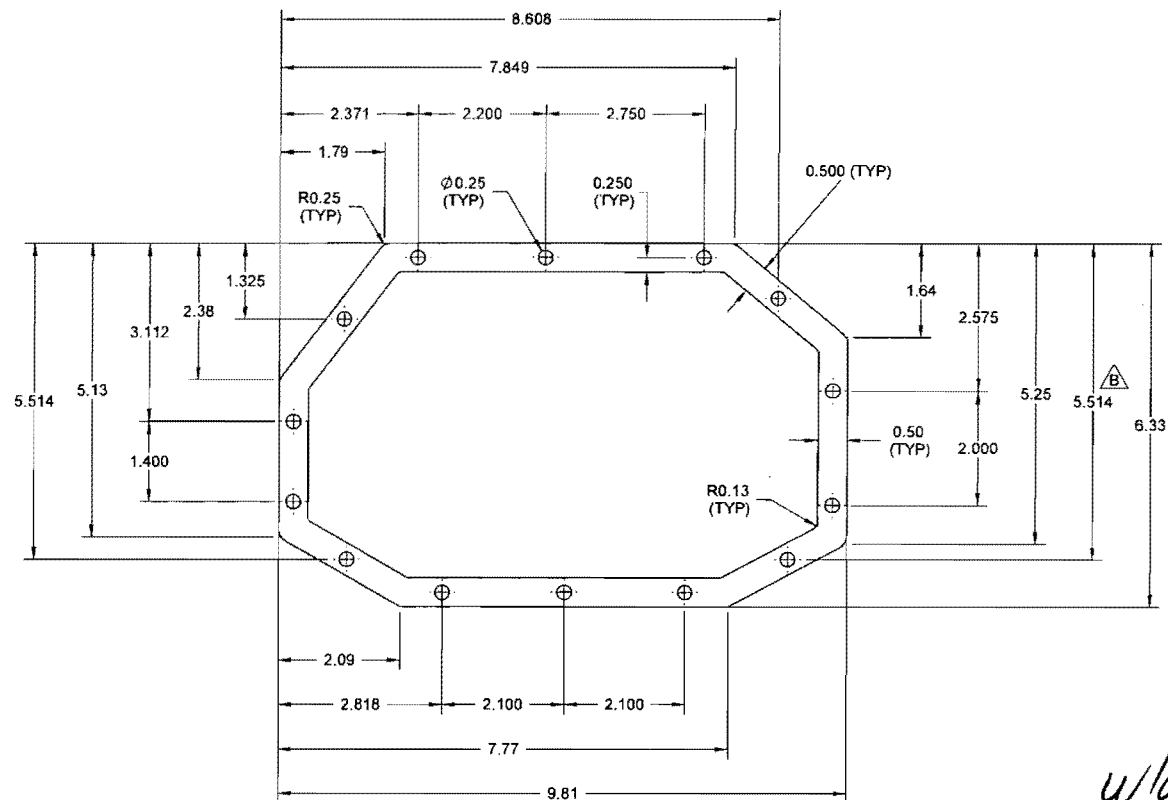
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3651-9 INSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

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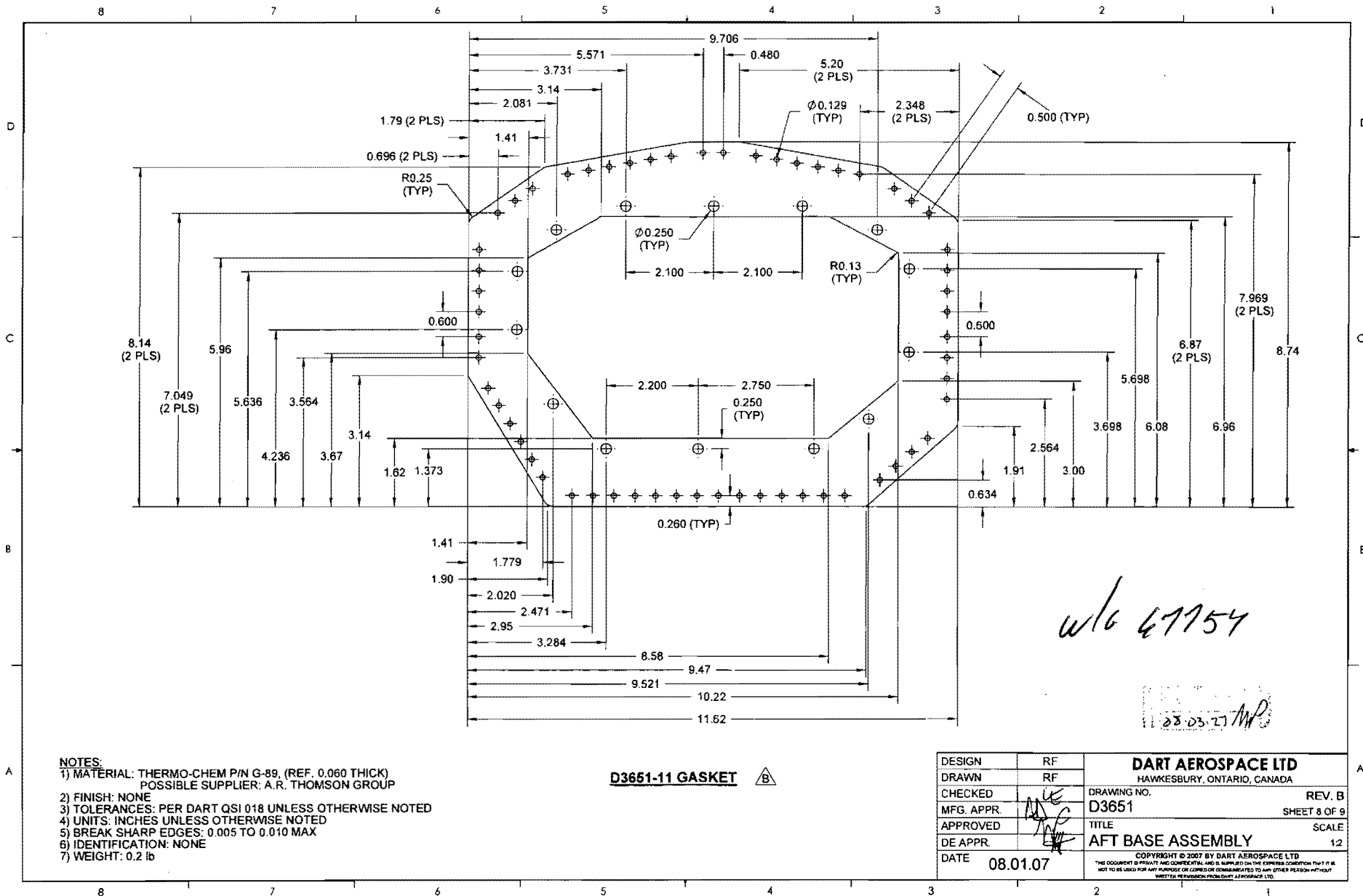
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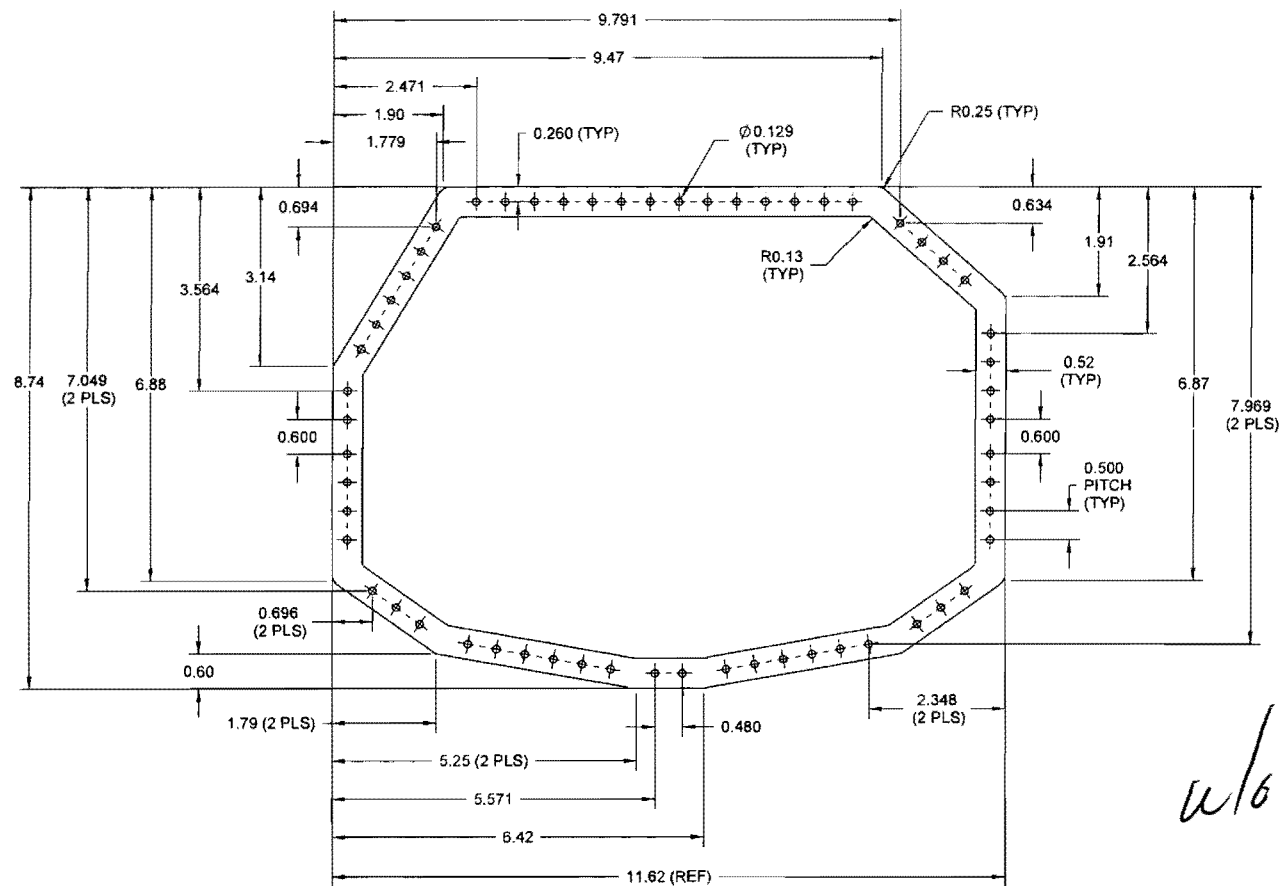
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


NOTE: Date & initial all entries



D3651-13 OUTSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED		DRAWING NO. D3651	REV. B
MFG. APPR.		SHEET 9 OF 9	
APPROVED		TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:2
DATE	08.01.07	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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08-03-27 MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries